



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D205-634-145
Job Sheet 202256



Part No: D205-634-145 Job Qty: 1 pcs
Part Name: Replacement Skidtube with Thru-Bolt Standard Wearplates Fits LH or RH

Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 10/23/19 Job Tracking No:
Due Date: 11/6/19 Created By: Marie Lajeunesse
Type: Stock Description:
Note: DWG D2580-049 REV H, IIN-D205-634 REV I IPP REV:B 14.04.21 NEW ISSUE DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1	11/6/19		0.00	0.33	Skidtubes - 1		MLA
		pcs					Skidtubes - 2		
		Skidtubes - 3							
		Skidtubes - 4							
		Skidtubes - 5							
		Skidtubes - 6							
		Skidtubes - 7							
120	Skidtubes - Bend - 2 - B4B	1	11/6/19		0.00	2.00	Skidtubes - Bend - B4B		MLA
		pcs							
130	Skidtubes - 2 - B4B	1	11/6/19		0.00	2.00	Skidtubes - 1 - B4B		MLA
		pcs					Skidtubes - 2 - B4B		
		Skidtubes - 3 - B4B							
		Skidtubes - 4 - B4B							
		Skidtubes - 5 - B4B							
		Skidtubes - 6 - B4B							
		Skidtubes - 7 - B4B							
140	QC 5	1	11/6/19		0.00	0.00	QC 5 - 10		BE
		pcs					QC 5 - 12		
		QC 5 - 17							
		QC 5 - 18							
		QC 5 - 19							
		QC 5 - 22							
		QC 5 - 24							
		QC 5 - 3							
		QC 5 - 43							
		QC 5 - 49							
		QC 5 - 51							
		QC 5 - 58							
		QC 5 - 68							
		QC 5 - 9							
		QC 5 - 50							



Container No: S227679

Part: D205-634-145
Job No: 202256
Serial No/Batch: S227679
Revision:
Inspector:
Exp Date:
Instructions: TC STC SH96-88 Issue 3, FAA-TC SR005631

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150 Skidtubes - 3 - B4B	1 pcs	11/6/19	0.00 1.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MCS
160 QC 10	1 pcs	11/6/19	0.00 0.00	Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
170 QC 5	1 pcs	11/6/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	NOV 04 2019 DAS 68 9-89
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	NOV 04 2019 DAS 68 9-89
				QC 5 - 9	
				QC 5 - 50	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	11/6/19	0.00 0.50	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Powdercoat - 1 White Gl(A)- B4B	1 pcs	11/6/19	0.00 1.00	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	NOV 04 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 QC 3	1 pcs	11/6/19	0.00 0.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BE 12-11-5
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	11-11-5
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	

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					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210 Handfinish - 3-1- WingWalk- B4B	1 pcs	11/6/19	0.00	2.00	Handfinish - 3 - 1 - B4B	HL 20-1-6
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
220 QC 5	1 pcs	11/6/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	JAN 13 2020 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
230 Packaging 3-1 - Stock - B4B	1 pcs	11/6/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	S209381
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	S177095
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	S184047
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	S216385
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	S103295
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	S221878x3
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	S206811
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	S045997
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	S194024
D5061-1	Fwd Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	S203051
D5061-3	Aft Wearplate	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	S205327
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	S089336
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	S178878

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	21	0
150-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	24	1,450	0
210-Handfinish - 3-1- WingWalk-B4B	AN3-5A	2	260	0
	AN4-45A	8	21	0
	D2570	16	193	0
	D2594-1	8	59	0
	D2594-3	8	466	0
	D2855	1	78	0
	D5061-1	1	9	0
	D5061-3	1	7	0
	MS21042-4	8	74	0
	NAS1149D0332J	2	1,516	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	QTY -045	QTY -047	QTY -446	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2580-1-100	EXTRUSION
21			10		D2570	BURNING
22	1	1	1	1	D2570-3	STEP
23		4			D2570	SPACER
24	10	10	5	5	D2584-1	PLUG
25	10	10	5	5	D2584-3	O-RING
26	1	1	1	1	D2580	203 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1			D2584-5	WEARSHOE
29	1	1			D2584-9	WEARSHOE
30	1	1			D2584-11	WEARSHOE
31	1	1			D2584-13	WEARSHOE
32	20	20	24	24	D4000-041	SPACER
33			1		D4000-045	WEARPLATE ASSEMBLY
34			1		D4000-048	WEARPLATE ASSEMBLY
35				1	D2001-1	FWD WEARPLATE
36				1	D2001-3	AFT WEARPLATE
60	50	50			AL57-1032-130 or AN57-1032-130 or AN54-1032-130 or MEL-5-1032-130	INSERT
61	50	50			AN50A	BOLT
62	2	2	2	2	AN5-5A	BOLT
63				5	AN4-5A	BOLT
64	50	50			AN51140C0322R	WASHER (AN500C10L)
65	2	2	2	2	WAS140C0322J	WASHER (AN500C10L)
66			5	5	ME21040-4	NUT (OR ME21040L4)

GENERAL NOTES:

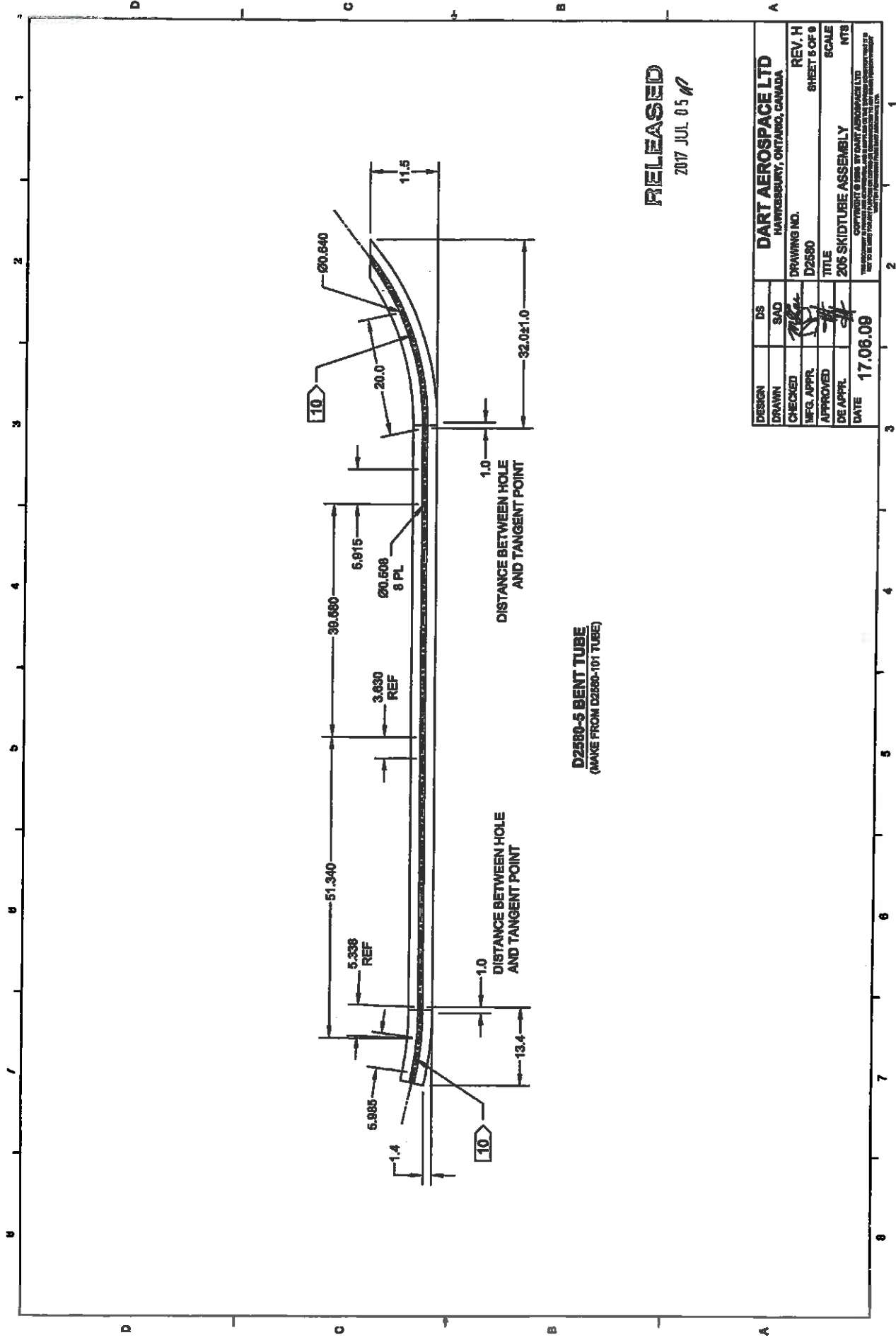
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QBI 006 4.1 PRIOR TO INSERTING D2580 WEB POWDER COAT (L414) (A74) (A9) GLOBS WHITE (REF 4.3.3.1) PER DART QBI 006 4.3 POWDER COAT (L414) (A74) (A9) GLOBS GREEN SANDTEX (REF 4.3.3.2) PER DART QBI 006 4.3 BLACK ANTI-SPIN PAINT AS INDICATED PER DART QBI 006 4.4.
- 3) TOLERANCES ARE PER DART QBI 019 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 53.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QBI 004.
- 9) INSERT D2580 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND SOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QBI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 50 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR217 & DTR267 ONLY FOR D2580-041/045 TO LOCATE AND DRILL 20.207 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B.9 AND F.5 (50 PLACES) AFTER FINISH. INSTALL AN50A BOLTS AND AN51140C0322R WASHERS WITH SIKAFLEX-241/251.
- 12) INSERT D2584-1 PLUG C/W D2584-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (18 PLACES FOR D2580-041/045 AND 8 PLACES FOR D2580-047/048).
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2580 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE

WORK ORDER
NO. 22-22-36 1105
19-10-23

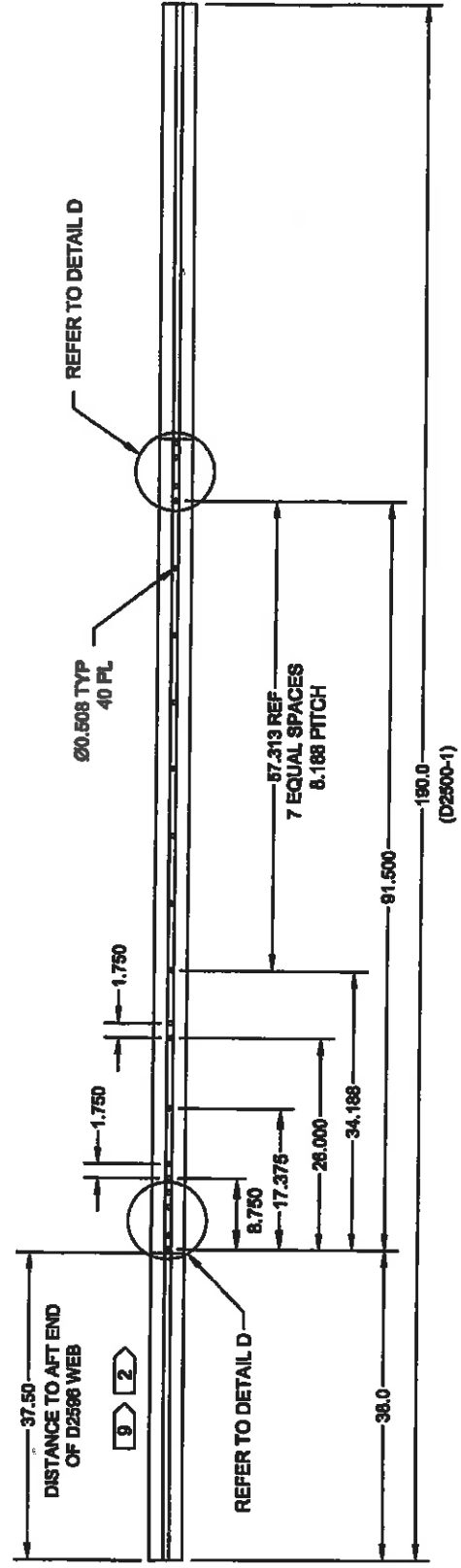
RELEASED
2017 JUL 05
EART-514

H	SHEET: PL DELETE D2580-1/41-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY, SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 0089	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART2-218	DC	13.06.20
E	ADD D2580-047 (2N CA-7) AND D2580-7 (2N ES-8); INCLUDED DEO D2580-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR267 WAS TO2577-205 (2N CA-1)	RF	11.06.21
D	CHANGE TO 55 WEARPLATES AND GASKETS, INCLUDE DEO 5124/ 5183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9294/ 0297	CP	06.08.20
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
MPR. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	17.06.09		
DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA			
REV. H DRAWING NO. D2580 SHEET 1 OF 9			
TITLE 205 SKIDTUBE ASSEMBLY			
SCALE NTP			
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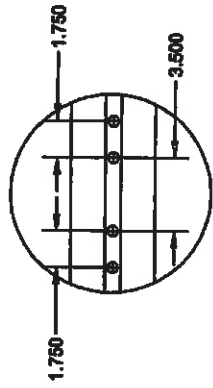


DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HARRISBURG, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D2580
APPROVED	<i>[Signature]</i>	TITLE
DE APPR.	<i>[Signature]</i>	206 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

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D2580-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

DESIGN	DB	DART AEROSPACE LTD
DRAWN	SAD	HAVERBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2580
APPROVED		TITLE
DE APPR.		208 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

REV. H
SHEET 8 OF 8

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NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)					
Description Work Order Deviation		Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
						Completed By			
						Lead hand / Supervisor			
						QC / QA Coordinator			

Change Record

PAGE 1 OF 1

Part Number: D205-634-145

Description: REPLACEMENT SKIDTUBE w/ THRU BOLT WEARPLATES

[illegible]